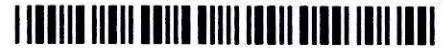




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2962-150
Job Sheet 206748



5264503

Part No: D2962-150

Job Qty: 88 pcs

82 PCS

Part Name: 3.540 Outer Tube, Extrud



603

MAR 18 2020

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/20

Job Tracking No:

Due Date: 3/11/20

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	88 pcs	3/11/20		0.00	0.00	Purchasing - 1	DAS 82 MAR 18 2020
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	88 pcs	3/11/20		0.00	0.00	Packaging 2 - 1 - B4B	DAS 82 MAR 18 2020
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

Plex 2/20/20 3:38 PM Dart.Guerin.Kimberley

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
120 QC 6	88 pcs	3/11/20	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	82
					QC 6 - 61	953
					QC 6 - 40	MAR 23 2020
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	88 pcs	3/11/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
140 QC 21 - SA	88 pcs	3/11/20	0.00 0.00		QC 21 - SA - 21	21
					QC 21 - SA - 70	9-00
					QC 21 - SA - 53	APR 22 2020

Part Op 100 - Issue P/O: H03045811 a) Extrude as per Dwg D2962 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield
 Descriptions: tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 150" long
 g) Bon L Canada Inc. tool # DAA-3 ***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF
 THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
 SCRATCHES, NICKS, OR DENTS.*** MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***
 110 - Ensure material certification is attached

- 120 - Check Pull test per Dwg D2962 for compliance page attached. Check hardness with Webster tester
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

PO Details

Signature Aluminum Canada Inc. (sig001-vc)



PO No: POHB045811

Line No: 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2962-150P	3.540 Outer Tube, Extrusion	88 pcs (1 ea)	100-Purchasing	5264500

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2962-150P	88	0	0

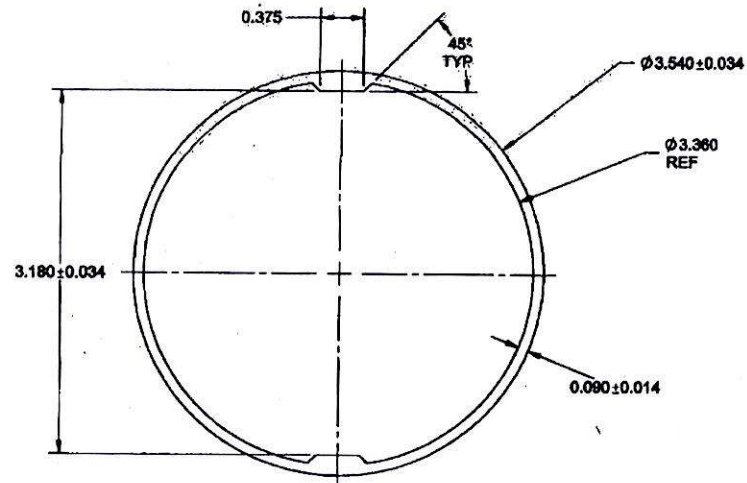
Part Specifications

Specifications could not be found.

Plex 2/20/20 3:38 PM Dart.Guerin.Kimberley

D2962-1SOP

LINE 1

DAS
82
9-89RELEASED
2013-06-21

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B221
 MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8%
 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

- 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.016 TO 0.025 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1
 7) WEIGHT: 0.105 lb/in
 8) MANUFACTURED USING BON L CANADA DIE # DAA-3
 9) NO TOOLING MARKS
 10) ORDER AS D2962-XXX WHERE XXX = LENGTH IN INCHES
 EG. 125 LONG: D2962-125

B	UPDATE FORMAT AND EXTRUSION TOLERANCES	SFM	13.05.09
A	NEW ISSUE	RF	00.03.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC KENT, WA	
DRAWN	SFM		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	MS	D2962	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EXTRUSION	NTS
DATE	13.05.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045811



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB045811
PO Date: 2/7/20
Due Date: 3/11/20
Purchase Order Revision:
Revision Date:
Issued By: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: quote no. 02062020-006

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206748	D2962-150P	D2962		3.540 Outer Tube, Extrusion : AS PER DWG D2962 REV. B DIE # DAA-3 150" LONG EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS	Firmed	-	3/11/20	88 pcs	0 pcs	88 pcs	\$39.56162/pcs	\$3,481.42
										82 PLS			
													MAR 18 2020
2	207256	D2962-190P	D3672	DAA-3	Extrusion as per DWG D2962 Rev B - 190" long EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES, NICKS and DENTS	Firmed	-	3/11/20	40 pcs	0 pcs	40 pcs	\$50.0717/pcs	\$2,002.87
										44 PCS			
													MAR 18 2020
												Grand Total:	\$5,484.29

K. Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045811



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 2/21/20 10:08 AM Dart.Guerin.Kimberley



1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST I

PACKING LIST DATE / DATE DU BODEREAU

03-16-20

PACKING LIST NUMBER / N° DE BODEREAU

047175

SALES ORDER NUMBER / N° DE COM

139335

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFÉREZ-VOUS À CES
NUMÉROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT		ORDER DATE / DE LA COM		CUSTOMER PO NUMBER / CLIENT PO Nombre		JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE	
46024		02/20/20		POHB045811		CANUS		G.ATTENBOROU		D1K	
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT		CARRIER / TRANSPORTEUR		SALES REP / REP. DES VENTES		CREDIT REP / REP DU CRÉDIT		SALES REP / REP. DES VENTES		SALES REP / REP. DES VENTES	
047175		CANUS		G.ATTENBOROU		G.ATTENBOROU		G.ATTENBOROU		G.ATTENBOROU	

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,390	LB		DAA-3-2	6061 T6		3	1,365	1,292	LB	
	631	KG		D2962-150P 150" MILL 6061 T6	150.0000 IN			619	586	KG	
Y	88	PC			Cut (+): 0.1180	Min: -10 % Max: 10 %			82	PC	
					Cut (-): 0.0000						

						933691 / 542692	1	434	410		26 PC
						933691 / 542693	1	465	441		28 PC
						933691 / 542694	1	465	441		28 PC

DAS
82
9-89

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

CUSTOMER

Page 1 of 2

DATE OF DELIVERY

DRIVER

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

		Continued	
TOTALS			

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

①

Cert Date	Cert No.	Sales Order	Page
03/13/2020	5573310	139335	1
Cust PO	B/L No.	Lot	Date
POHB045811	047175	933691	03/16/20

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-3-2	150" MILL 6061 T6 ✓	D2962-150P 150"MILL6061T6 ✓
Gross Weight	1,365 LBS		
Net Qty	1,292 LBS	82 PCS	3 PKGS
Specification		Die Desc	
AMS QQA 200/9 + ASTM B221-08 ✓			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
<u>MPA / KSI</u>	<u>MPA / KSI</u>			
274.5 / 39.8 ✓	244.2 / 35.4 ✓	10.4 ✓	N/A	91

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.62	0.27	0.20	0.07	0.87	0.06	0.06	0.02	0.01	0.00

RECEIVED
MAR 17 2020
DART AEROSPACE LTD.

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

LINE 1

MATERIAL RECEIPT INSPECTION FORM

 MATERIAL: D2962-150P
 DATE: MAR 23 2020

 PO / BATCH NO.: POHBO45811
S264500

 MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 82 PCS
 QUANTITY INSPECTED: 82 PCS
 QUANTITY REJECTED:

 THICKNESS ORDERED:
 THICKNESS RECEIVED:
 SHEET SIZE ORDERED:
 SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	AMS - QQ - A - 200
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HIT 933691
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u> </u>	SIGNED OFF BY: <u> </u>		
DATE: <u>MAR 23 2020</u>	DATE: <u> </u>		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

Guillaume Gamache-Beauchamp

From: Patrick Duval
Sent: 16 mars 2020 15:08
To: Guillaume Gamache-Beauchamp
Subject: FW: Guillaume QC6

FYI

Pat Duval

From: Patrick Duval
Sent: March 16, 2020 2:15 PM
To: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>; 'Marie Lajeunesse (mlajeunesse@dartaero.com)' <mlajeunesse@dartaero.com>; Zoe Evans (zevans@dartaero.com) <zevans@dartaero.com>; 'Shannon Hadley (shadley@dartaero.com)' <shadley@dartaero.com>
Cc: Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Serge Carriere (scarriere@dartaero.com) <scarriere@dartaero.com>; Valerie Miller <vmiller@dartaero.com>
Subject: Guillaume QC6

All

I have received & reviewed the training from Guillaume Gamache-Beauchamp regarding his inspection levels for QC6 and he is competent to perform this inspection levels.

Zoe,

Please adjust his training recorded to show that he has completed his training. (Stamp 82)

Shannon,

Please add the appropriate work center

Pat Duval
QC Coordinator

DART AEROSPACE
T: 1-613-632-5200 ext.228
www.dartaero.com
pduval@dartaero.com

